

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002537**Date Inspected:** 15-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** C. M. Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

New Tower Shop Bay 3:

The QA Inspector performed Visual Inspection of repairs to Weld Joints (WJ's) DP039-001-007 through DP039-001-010 on Deck Panel DP039-001. Inspection data recorded on a separate spreadsheet. The attached photograph provides additional detail.

The QA Inspector performed Visual Inspection of repairs to Weld Joints (WJ's) DP080-001-001 through DP039-001-003 on Deck Panel DP080-001. Inspection data recorded on a separate spreadsheet. The attached photographs provide additional detail.

New OBG Bay 2:

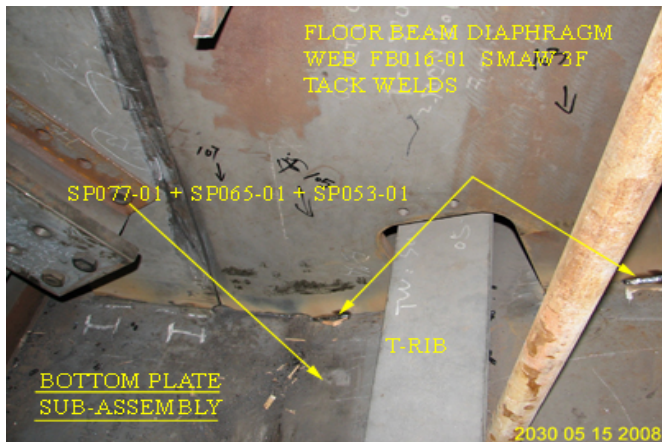
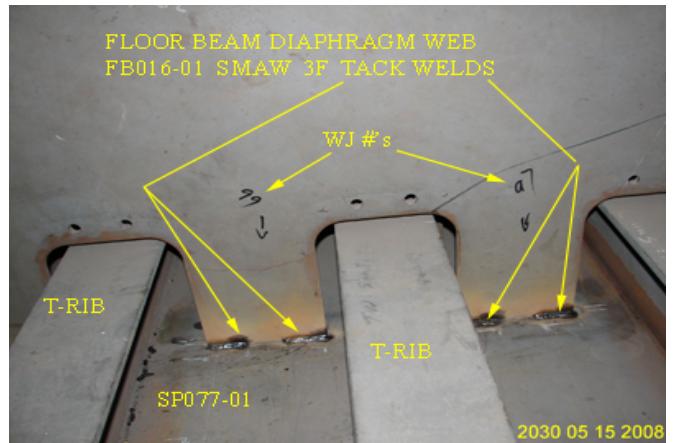
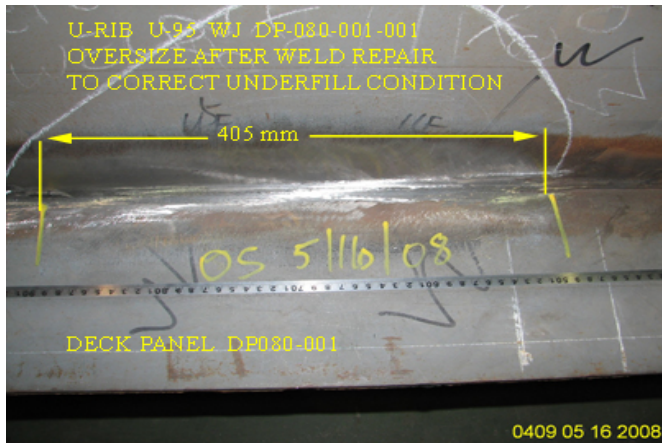
The QA Inspector randomly observed ZPMC welder Xu Liguang ID Number 200114, utilizing the Shielded Metal Arc Welding (SMAW) Process to tack weld during fit up, the bottom of a web of Floor Beam FB016-01 to Side Plate Sub-Assembly SP053-01 + SP065-01 + SP077-01. The QA Inspector randomly observed ZPMC CWI C. M. Chen monitoring weld parameters. The attached photographs provide additional detail.

The QA Inspector randomly observed a ZPMC helper grinding flush weld reinforcement, to repairs to WJ

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SEG-019A-004 in Bottom Plate Sub-Assembly BP020A + BP021A. The attached photographs provide additional detail.



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Summary of Conversations:

There were no relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
